ASAD

Work Order ID 103938 \*103938\* Page 1 Friday, July 05, 2013 9:07:49 AM Item ID: D3925-3 Accept \*N900040100\* Setup Start **Revision ID:** Seatbelt Reel Bracket Item Name: \*6\* **Start Date:** 7/5/2013 Start Qty: 6.00 **Cust Item ID:** Required Date: 7/12/2013 Req'd Qty: 6.00 **Customer:** Reference: Run Process Plan: MF. Date: 13-7-5 Tooling: Approvals: Date: QC: \_\_\_\_\_ Date: SPC (Y/N): Date: Operation Sequence ID/ Set Up/ Tool # Plan Tool ID Reject Reject Accept Insp. Work Center ID Description **Run Hours** Code Qty **Qty** Number Stamp Draw Nbr **Revision Nbr** D3925 Α 0.00 FLOW WATER JET \*100\* Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg Dwg Rev: A Prog Rev: A 600e1.125" 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 6 0 Jui307.08 \*110\* 0.00 Memo Quality Control QC8- Inspect parts - second check 0.00 \*120\* QC Memo

Quality Control

DQA:			Date:										*	DART
QA Closed:			Date:			WORK ORDER NON	-C(	ONFO	RMANCE / UPDATE					AEROSPACE
QA Closed.	-		Date.				-			VV	ork Order up	date only		
Work Orde	er:					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS		
	i l l					Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Crosstube  Machining Small Fab  noforming Finishing  Large Fab Composite		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Quality Other
Root					Desci	ription of work order update	1	nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	ı	QC Inspector
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Offset/Setup														
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	Ce	ntre No	t Concer	ntric		BOM/Route		Grain		一	Over/Under	- F	-	Set-up
	Cra	acks				Broken/Damage/Defect		Hardwa	are		Part Incorred	}		Temperature/Cure
	Cri	mp/Kin	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi			Weld
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	Ins	pection	Strip in	Tube		Drawing		Misread			·	· [		
	М	arks/Ch	atter			Drill Holes		Off-set						
	Tu	rning Se	equence			Finish		1	Calibration					
	$\square_{w}$	ave/Twi	st in Tub	ne		Fit/Function		4	Seguence					

Work	Order ID	103938
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\*103938\* Page 2 Friday, July 05, 2013 9:07:49 AM Item ID: D3925-3 Accept \*N900040100\* Setup Start \*NS1\* Revision ID: Seatbelt Reel Bracket Item Name: 7/5/2013 Start Date: Start Qty: 6.00 **Cust Item ID:** Required Date: 7/12/2013 Req'd Qty: 6.00 **Customer:** Reference: Run Process Plan: \_\_\_\_\_ Date: \_\_\_\_ Tooling: Approvals: Date: Stop Date: \_\_\_\_\_ QC: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Insp. Accept Reject Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 130 Form as per dwg 0.00 NC BRAKE \*130\* Brake NC 0.00 Memo Brake NC 140. QC5- Inspect part completeness to step on W/O \*140\* QC: Memo Quality Control

Chemical Conversion Coat per QSI005 4.1

0.00

\*150\* HandFinish

Memo

0.00

Hand Finishing

V613-7.9

DQA:			Date:											***************************************	NA PT
						WORK ORDER NON	-CC	ONFO	RMANCE / U				_		AEROSPACE
QA Closed:	-		Date:					<b>-</b>		*	W	ork Order up	odate only	$oldsymbol{\perp}$	
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Cause		Date	Step	Qty	Desci	or non-conformance		nief Eng	Descr			Date	Verification	$\cdot \mid$	QC Inspector
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H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Orde Friday, July 05,				*1039	38*					Page 3
Revision ID: Item Name:	D3925-3 Seatbelt Reel			Accept *	N900040	100	)*	Setup Sta	1 \	IS1* IS2*
Start Date: Required Date: Reference:	7/5/2013 7/12/2013	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item ID: Customer:					
Approvals:		in:	Date:	Tooling: SPC (Y/N):	Date:			Run Sta	1/7	R1*  R2*
Sequence ID/ Work Center II  160 *160* QC Quality Control	)	Operation Description QC7-Inspect Chemical Co	onversion Coat	Set Up/ Run Hours 0.00	Tool ID Tool #	Plan Code	Accep Qty	t Reject Qty	Reject Number	Insp. Stamp
170 *170* Packaging Packaging		Identify as per dwg & Stoo	ck Location:	0.00			6x		-	SP 13-7-9
*180* QC Quality Control		QC21- Final Inspection - V	Work Order Release	0.00				13/7	104	) NVF (3-9-90

DQA:			Date:												PT
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	_					Use-as-is	1		noforming	Finishing	$\dashv$		re/Packaging	Oth	· H 1
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!	$\vdash$	Cracks	or concer	HILL	$\vdash$	Broken/Damage/Defect	-	Hardwa	aro.			Over/Under Part Incorred	<b>⊢</b>	Set-up Temperature	o/Curo
	⊢	Crimp/Kir	k/Rinnla	Mayo	-	Burrs	<u> </u>	1	ire ion Incomplete/L	Inqualified	-	Part Lost/Mi	<b>⊢</b>	Weld	e/Cure
;	$\blacksquare$	Cuffs	iky itippie	, wave	-	Contamination	$\vdash$	1 '	tions incomplete/c	•	$\boldsymbol{\dashv}$	Part Moved	221118	Wrong Stock	Pulled
•	<del></del>	Crushing			-	Countersink	$\vdash$	•	ned/off center	1	_	Positioned V	Vrong		rulleu
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## **Picklist Print**

Friday, July 05, 2013 9:07:49 AM

Work Order ID:

103938

Parent Item:

D3925-3

Parent Item Name:

Seatbelt Reel Bracket

**Start Date:** 7/5/2013

Required Date: 7/12/2013

Page 1

Start Qty: 6.00

Required Qty: 6.00

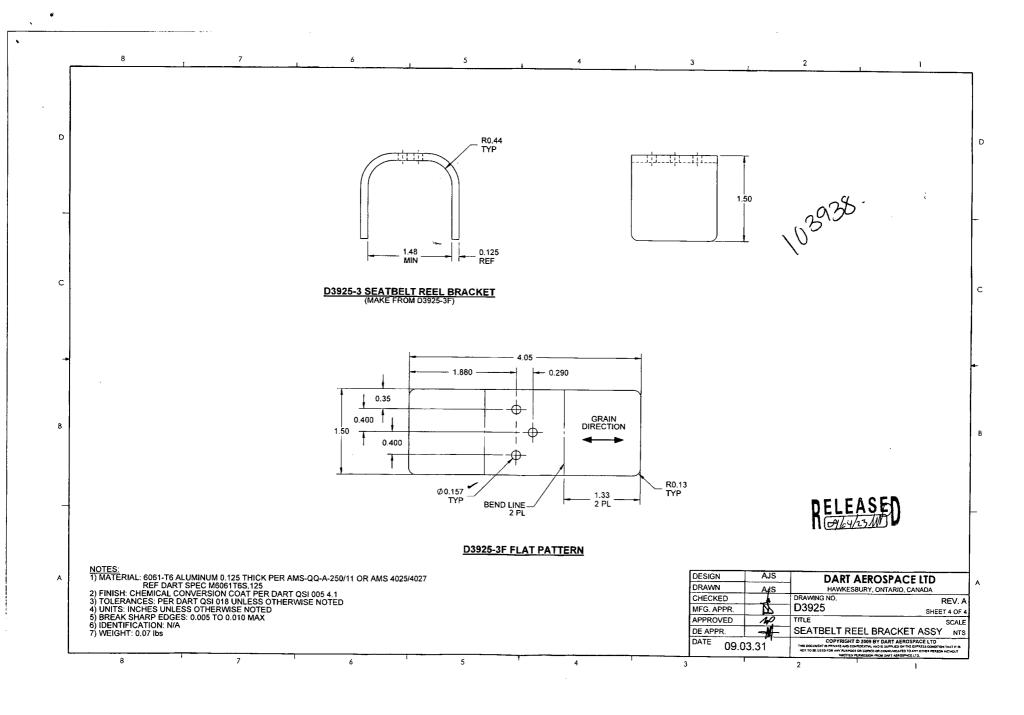
Comments:

IPP REV:A 13.07.04 PER DWG REV.A DD VERF:JFS

				20 12101.010	,								
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 6061-T6 .125 Sheet		Purchased	No				sf	147.5562		0.26 <del>3</del> 2632	, }		IMB-07-08
				Location		Loc Oty	<u>Lo</u>	c Code					
				MAT021		147.5561578							
				121	473	0.9161578				<del></del>			
				123	279	72.89							
				125	257	41.75							
				M1	26075	32			176	VF25			

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Part N					<del></del>	Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Crosstube  Machining Small Fab  noforming Finishing  Large Fab Composite	Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other
Root					Desci	ription of work order update	l i	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved													
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Landi	ng Ge	ear				General					_		
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	ΙÍν	Nave/Tw	ist in Tub	e e		Fit/Function ·		Out of 9	Sequence				

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DQA:			Date:											
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Part I	•					Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		1	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root					Desc	ription of work order update	Ī	nitial	Ad	ction		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	cription		Date	Verification	QC Inspector
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		Wave/Tw	ist in Tub	e		Fit/Function	:	Out of S	Sequence					

DART AEROSPACE LTD	Work Order:	103938
	`	
Description: Seathelt Keel Bruket	Part Number:	03925-3
Inspection Dwg: 03935 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.157	to.005-0.001	0.160			V	Jemo1
1.50	41-0.030"	1.507			V	
0,400"	11-0:010"	0.400	_		ν	
0,400	41-0.010	0,400	_		V	
6.35	120.030	0.353"	)		V	
1.8804	41-0.010	1,983"	1		V	
0.290	11-0.010"	0.294"	į		V	
4.05"	11-0.030	4.047	_		V	
0.125	41-0.010"	0.621	)		V	
						A
						100 - 100

Measured by:	Jm	Audited by:		Preliminary Approval:	
Date:	13-07-05	Date:	1378	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

A 10.04.15